

## Section 1. Registration Information

### Source Identification

---

Facility Name:	Sara Lee Mixing Facility
Parent Company #1 Name:	Sara Lee Corporation
Parent Company #2 Name:	

### Submission and Acceptance

---

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	05-Nov-2010
Postmark Date:	05-Nov-2010
Next Due Date:	05-Nov-2015
Completeness Check Date:	05-Nov-2010
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

### Facility Identification

---

EPA Facility Identifier:	1000 0019 3818
Other EPA Systems Facility ID:	

### Dun and Bradstreet Numbers (DUNS)

---

Facility DUNS:	5213962
Parent Company #1 DUNS:	
Parent Company #2 DUNS:	

### Facility Location Address

---

Street 1:	501 South 107th Avenue
Street 2:	
City:	Tolleson
State:	ARIZONA
ZIP:	85353
ZIP4:	
County:	MARICOPA

### Facility Latitude and Longitude

---

Latitude (decimal):	33.438333
Longitude (decimal):	-112.288611
Lat/Long Method:	Interpolation - Photo
Lat/Long Description:	Center of Facility
Horizontal Accuracy Measure:	25
Horizontal Reference Datum Name:	North American Datum of 1983
Source Map Scale Number:	24000

## Owner or Operator

---

Operator Name:	Mike Nelson
Operator Phone:	(623) 907-2720

## Mailing Address

---

Operator Street 1:	501 South 107th Avenue
Operator Street 2:	
Operator City:	Tolleson
Operator State:	ARIZONA
Operator ZIP:	85353
Operator ZIP4:	
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

## Name and title of person or position responsible for Part 68 (RMP) Implementation

---

RMP Name of Person:	Travis Mangus
RMP Title of Person or Position:	Refrigeration Manager
RMP E-mail Address:	travis.mangus@totallogistic.com

## Emergency Contact

---

Emergency Contact Name:	Travis Mangus
Emergency Contact Title:	Refrigeration Manager
Emergency Contact Phone:	(623) 907-2720
Emergency Contact 24-Hour Phone:	(623) 907-2720
Emergency Contact Ext. or PIN:	369
Emergency Contact E-mail Address:	travis.mangus@totallogistic.com

## Other Points of Contact

---

Facility or Parent Company E-mail Address:
Facility Public Contact Phone:
Facility or Parent Company WWW Homepage Address:

## Local Emergency Planning Committee

---

LEPC:	Maricopa County LEPC
-------	----------------------

## Full Time Equivalent Employees

---

Number of Full Time Employees (FTE) on Site:	80
FTE Claimed as CBI:	

## Covered By

---

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	
Air Operating Permit ID:	

## OSHA Ranking

---

OSHA Star or Merit Ranking:

## Last Safety Inspection

---

Last Safety Inspection (By an External Agency) Date:	30-Sep-2010
Last Safety Inspection Performed By an External Agency:	Fire Department

## Predictive Filing

---

Did this RMP involve predictive filing?:

## Preparer Information

---

Preparer Name:	Travis Mangus
Preparer Phone:	(623) 764-5166
Preparer Street 1:	501 S 107 Ave
Preparer Street 2:	
Preparer City:	Tolleson
Preparer State:	ARIZONA
Preparer ZIP:	85353
Preparer ZIP4:	
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

## Confidential Business Information (CBI)

---

CBI Claimed:  
Substantiation Provided:  
Unsanitized RMP Provided:

## Reportable Accidents

---

Reportable Accidents:	See Section 6. Accident History below to determine if there were any accidents reported for this RMP.
-----------------------	---

## Process Chemicals

---

Process ID:	1000021666
Description:	Ammonia Refrigeration
Process Chemical ID:	1000025611
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	17000
CBI Claimed:	
Flammable/Toxic:	Toxic

## Process NAICS

---

Process ID:	1000021666
Process NAICS ID:	1000021968
Program Level:	Program Level 3 process
NAICS Code:	49312
NAICS Description:	Refrigerated Warehousing and Storage

## Section 2. Toxics: Worst Case

Toxic Worst ID: 1000017675

---

Percent Weight:

Physical State:

Model Used:

Gas liquified by refrigeration

EPA's RMP Guidance for Chemical Distributors  
Reference Tables or Equations

Release Duration (mins):

10

Wind Speed (m/sec):

1.5

Atmospheric Stability Class:

F

Topography:

Rural

### Passive Mitigation Considered

Dikes:

Enclosures:

Berms:

Drains:

Sumps:

Other Type:

## Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000019205

---

Percent Weight:

Physical State:

Model Used:

Wind Speed (m/sec):

Atmospheric Stability Class:

Topography:

Gas liquified by refrigeration

EPA's RMP Guidance for Warehouses Reference  
Tables or Equations

3.0

D

Rural

### Passive Mitigation Considered

Dikes:

Enclosures:

Berms:

Drains:

Sumps:

Other Type:

Yes

### Active Mitigation Considered

Sprinkler System:

Deluge System:

Water Curtain:

Neutralization:

Excess Flow Valve:

Flares:

Scrubbers:

Emergency Shutdown:

Other Type:

Yes

## **Section 4. Flammables: Worst Case**

No records found.

## **Section 5. Flammables: Alternative Release**

No records found.



## Section 6. Accident History

No records found.

## Section 7. Program Level 3

### Description

The facility operates in accordance with the International Institute of Ammonia Refrigeration (IAR) guidelines and standards including the following:

### Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000021560
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7

Prevention Program Level 3 ID:	1000018156
NAICS Code:	49312

### Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	14-Feb-2006
---	-------------

### Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	14-Feb-2006
---	-------------

### The Technique Used

What If: Checklist: What If/Checklist: HAZOP: Failure Mode and Effects Analysis: Fault Tree Analysis: Other Technique Used:	Yes
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	14-Feb-2007

### Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	Yes
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	Yes
Earthquake:	Yes

Floods (Flood Plain):

Tornado:

Hurricanes:

Other Major Hazard Identified:

## Process Controls in Use

---

Vents: Yes

Relief Valves: Yes

Check Valves: Yes

Scrubbers:

Flares:

Manual Shutoffs: Yes

Automatic Shutoffs: Yes

Interlocks: Yes

Alarms and Procedures: Yes

Keyed Bypass:

Emergency Air Supply:

Emergency Power: Yes

Backup Pump:

Grounding Equipment:

Inhibitor Addition:

Rupture Disks: Yes

Excess Flow Device:

Quench System:

Purge System:

None:

Other Process Control in Use:

## Mitigation Systems in Use

---

Sprinkler System:

Dikes:

Fire Walls: Yes

Blast Walls:

Deluge System:

Water Curtain:

Enclosure: Yes

Neutralization:

None:

Other Mitigation System in Use:

## Monitoring/Detection Systems in Use

---

Process Area Detectors: Yes

Perimeter Monitors:

None:

Other Monitoring/Detection System in Use: Electronic rupture disk

## Changes Since Last PHA Update

---

Reduction in Chemical Inventory:

Increase in Chemical Inventory:

Change Process Parameters:

Installation of Process Controls:

Installation of Process Detection Systems:  
Installation of Perimeter Monitoring Systems:  
Installation of Mitigation Systems:  
None Recommended:  
None: Yes  
Other Changes Since Last PHA or PHA Update:

## Review of Operating Procedures

---

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures): 08-Sep-2010

## Training

---

Training Revision Date (The date of the most recent review or revision of training programs): 08-Sep-2010

## The Type of Training Provided

---

Classroom: Yes  
On the Job: Yes  
Other Training:

## The Type of Competency Testing Used

---

Written Tests: Yes  
Oral Tests: Yes  
Demonstration:  
Observation: Yes  
Other Type of Competency Testing Used:

## Maintenance

---

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures): 08-Sep-2010

Equipment Inspection Date (The date of the most recent equipment inspection or test): 01-Sep-2010

Equipment Tested (Equipment most recently inspected or tested): Annual Mechanical integrity

## Management of Change

---

Change Management Date (The date of the most recent change that triggered management of change procedures): 03-Feb-2010

Change Management Revision Date (The date of the most recent review or revision of management of change procedures): 03-Feb-2010

## Pre-Startup Review

---

Pre-Startup Review Date (The date of the most recent pre-startup review): 16-Feb-2006

## Compliance Audits

---

Compliance Audit Date (The date of the most recent compliance audit): 25-Jun-2009

Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit): 25-Jun-2010

## Incident Investigation

---

Incident Investigation Date (The date of the most recent incident investigation (if any)): 29-Nov-2005

Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation): 29-Nov-2006

## Employee Participation Plans

---

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans): 08-Nov-2005

## Hot Work Permit Procedures

---

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures): 15-Aug-2007

## Contractor Safety Procedures

---

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures): 08-Sep-2010

Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance): 08-Sep-2010

## Confidential Business Information

---

CBI Claimed:

## Section 8. Program Level 2

## Section 9. Emergency Response

### Written Emergency Response (ER) Plan

---

Community Plan (Is facility included in written community emergency response plan?): Yes

Facility Plan (Does facility have its own written emergency response plan?): Yes

Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?): Yes

Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?): Yes

Healthcare (Does facility's ER plan include information on emergency health care?): Yes

### Emergency Response Review

---

Review Date (Date of most recent review or update of facility's ER plan): 15-Sep-2010

### Emergency Response Training

---

Training Date (Date of most recent review or update of facility's employees): 15-Sep-2010

### Local Agency

---

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated): Tolleson Fire Department

Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated): (623) 936-8500

### Subject to

---

OSHA Regulations at 29 CFR 1910.38: Yes

OSHA Regulations at 29 CFR 1910.120:

Clean Water Regulations at 40 CFR 112:

RCRA Regulations at CFR 264, 265, and 279.52:

OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:

State EPCRA Rules or Laws: Yes

Other (Specify):

## Executive Summary

### Executive Summary

#### Scope

The EPA RMP regulation requires that an Executive Summary be provided as part of this registration submitted to the EPA. The following areas are addressed in this summary:

- A. Accidental Release Prevention and Emergency Response Policies
- B. Stationary Source Activities And Regulated Substances Handled
- C. Prevention Program
- D. Five-Year Accident History
- E. Emergency Response Program
- F. Planned Changes to Improve Safety

#### A. ACCIDENTAL RELEASE PREVENTION AND EMERGENCY RESPONSE POLICIES

The emergency response procedures are detailed in the Sara Lee Mixing Facility Emergency and Hazardous Materials Response Plans and Procedures. These manuals were designed to meet the following objectives:

- 1) To save lives.
- 2) To minimize and avoid injuries.
- 3) To protect the environment and the public.
- 4) To minimize property damage.

The Emergency Response Plan and Procedures provides the reporting and notification procedures, evacuation procedures, and mitigation procedures that may be implemented to ensure operators respond effectively to an emergency situation. All employees are trained in their specific roles when responding to an emergency. The manuals are kept in strategic locations throughout the facilities and are readily available to all employees.

#### B. STATIONARY SOURCE AND REGULATED SUBSTANCE

The ammonia refrigeration system is a closed system that cycles the refrigerant, or ammonia, from liquid to gas and back again. The system, consisting of vessels, interconnecting piping, valves, and process equipment, cycles ammonia through various states (high pressure liquid, low pressure liquid, low pressure vapor, high pressure vapor, then back to high pressure liquid) in order to provide refrigeration for product and process equipment.

Changes in pressure are directly related to changes in temperature: lowering the ammonia pressure lowers its temperature. Low-pressure (cold) liquid ammonia provides refrigeration by removing ambient heat. Removal of ambient heat causes the liquid ammonia (contained within the system) to vaporize. Heat is latter removed from the ammonia as it is condensed back into a liquid. Typical operating conditions range from 5" hg on the low side to 150 psig on the high side.

Ammonia is used as the refrigerant in the refrigeration process.

The maximum intended inventory of ammonia is 17,000 pounds.

#### C. ACCIDENTAL RELEASE PREVENTION PROGRAM

The facility operates in accordance with the International Institute of Ammonia Refrigeration (IIAR) guidelines and standards including the following:

ANSI/IIAR 2-1999 Equipment Design, and Installation of Ammonia Mechanical Refrigerating Systems

IIAR Bulletin 107, A Suggested Safety and Operating Procedures When Making Ammonia Refrigeration Tie-ins@



IIAR Bulletin 109, Minimum Safety Criteria for a Safe Ammonia Refrigeration System@

IIAR Bulletin 110, "Startup, Inspection, and Maintenance of Ammonia Refrigeration Systems"

IIAR, A Guide to Good Practices for the Operation of an Ammonia Refrigeration System@

In addition the Sara Lee Mixing Facility has implemented a Process Safety Management program for compliance with CFR 29, 1910.119. This included an initial Process Hazard Analysis that is revalidated every five years. In addition, the facility has a Mechanical Integrity program that includes an Engineering Checklist for equipment inspections.

#### D. FIVE YEAR ACCIDENT HISTORY

There have been no reported releases of ammonia at this facility over the last eight years (December 2002 through October 19, 2010).

#### E. EMERGENCY RESPONSE PROGRAM

TLC's Emergency Response Program is described in their Emergency Response Plan (ERP) for the Tolleson facility. This plan includes planned responses and procedures for evacuation. Notification and alarm procedures are outlined in the ERP as well. The plan addresses training requirements for employees, including production employees, supervisors, managers, and operators. Emergency response drills involving all facility personnel are performed on an annual basis. This ensures that employees are familiar with evacuation routes from the facility and employee roles.

#### F. PLANNED CHANGES TO IMPROVE SAFETY

Sara Lee Mixing Facility will maintain PSM /RMP programs for continued process safety improvement. This will be accomplished through audits, PHA revalidations, training, mechanical integrity testing and inspections. As a result of the initial PHA several improvements to safety have occurred: develop more written procedures, establish backup support from local refrigeration contractor or equal, protect evaporators from forklift impact in refrigerated areas.